

Work Order ID 129699

February-23-15 10:16:50 AM

129699

Page 1

Item ID: D3278-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 2/23/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-02-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3278	Rev C

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab Rivet spacers with support as per Dwg D3278.

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

120 Small Fab 0.00
120
 Small Fab Memo 0.00
 Small Fab Assemble support as per Dwg D3278.***DO NOT TIGHTEN
 BOLTS***Identify as D3278-041

30x 15/03/05 DAS 36 9-89

30 15/03/05 DAS 30 9-89

30x 15/03/05 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other	Other
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

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Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>S1523</u>	0.00							DAS 06 9-89
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MAR 05 2015

MAR 16 2015

MCS 1503-16

MCS 1503-16

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 129699

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A *AN4-13A* Bolt		Purchased	No			120	Each	422.0000	2	60		15/03/05	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				20					
				122808				20					
				GA				43					
				m130325				43					
				ST325A				359					
				m130716				1					
				m131305				258		60			
				m131624				100					
D2230-1 *D2230-1* Mounting Lug		Manufactured	No			120	Each	345.0000	2	60		15/03/05	DAS 36 2-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				4					
				84136				4					
				ST521				122					
				115306				80					
				116380				31					
				116381				11					
				ST546A				219					
				112595				1					
				113437				112					
				116381				89		60			
				116382				17					

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 129699

Parent Item: D3278-041

Parent Item Name: Support Assembly

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D3278-041

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 30.00

Required Qty: 30.00

D3278-1 Manufactured No

100 Each 45.0000 1 30

D3278-1

Support

**

DAS
36
9-89

15/03/05

Location

Loc Qty

Loc Code

GA

45

121508

2

123402

43

2
28

D3278-2 Manufactured No

100 Each 44.0000 1 30

D3278-2

Support

**

DAS
36
9-89

15/03/05

Location

Loc Qty

Loc Code

GA

44

121685

1

123516

43

1
29

D3278-3 Manufactured No

100 Each 103.0000 1 30

D3278-3

Spacer

**

DAS
36
9-89

15/03/05

Location

Loc Qty

Loc Code

GA

103

121680

103

30

* MS20426AD3-6 Purchased No

120 Each 1,166.000 4 120

MS20426AD3-6

Rivet

**

DAS
36
9-89

15/03/05

Location

Loc Qty

Loc Code

GA

1166

116289

1166

22 = 0

M120123
1204

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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129699

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 30.00

Required Qty: 30.00

MS21042L4

Purchased

No

100

Each

3,991.000

2

60

MS21042L4

Locknut

15/03/05

DAS

36

9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

1146

m130799

62

m131340

1084

ST305

2099

426

426

m128300

8

m128798

8

m130922

101

m131618

1556

NAS1149D0463J

Purchased

No

120

Each

5,594.000

4

120

NAS1149D0463J

WASHER

15/03/05

DAS

36

9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1151

M129390

1151

ST269

3638

M130799

638

M131624

3000

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